



**Work Order ID 153577**

Tuesday, November 22, 2016 10:34:54 AM

**\*153577\***

Page 2

Item ID: D3447-5

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Clevis

Stop

**\*NS2\***

Start Date: 11/22/2016 Start Qty: 8.00

**\*8\***

Cust Item ID:

Required Date: 12/2/2016 Req'd Qty: 8.00

**\*8\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*130\***

QC

Memo

0.00

Quality Control

10

0

DAS  
32  
9-89

16-11-30

140

QC8- Inspect parts - second check

0.00

**\*140\***

QC

Memo

0.00

Quality Control

10

0

DAS  
44  
9-89

16-11-30

150

Chemical Conversion Coat per QSI005 4.1

0.00

**\*150\***

Hand/Finish

Memo

0.00

Hand Finishing

x10

0

2016/12/02  
BEB

ork Order ID 153577  
uesday, November 22, 2016 10:34:54 AM

\*153577\*

m ID: D3447-5 Accept \*N900040100\* Setup Start \*NS1\*  
vision ID: Stop \*NS2\*  
m Name: Clevis  
rt Date: 11/22/2016 Start Qty: 8.00 \*8\* Cust Item ID:  
quired Date: 12/2/2016 Req'd Qty: 8.00 \*8\* Customer:  
ference:

provals: Process Plan: Date: Tooling: Date: Run Start \*NR1\*  
QC: Date: SPC (Y/N): Date: Stop \*NR2\*

| quence ID/<br>ork Center ID      | Operation<br>Description                                                                                               | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp               |
|----------------------------------|------------------------------------------------------------------------------------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|------------------------------|
| 160*<br>wdercoat<br>vder Coating | Green Sandtex(Ref:4.3.5.8) per QSI005 4.3<br><i>M134092</i>                                                            | 0.00                 |         |        |              | <i>10</i>     | <i>0</i>      | <i>10-12-15</i>  | <i>338</i>                   |
|                                  | Memo<br>Mask 0.875" round section<br>TEMPERATURE: <i>320°</i> START TIME: <i>3:45</i> OVEN<br>FINISH TIME: <i>4:15</i> | 0.00                 |         |        |              |               |               |                  |                              |
| 170*<br>ality Control            | QC3- Inspect Part Finish                                                                                               | 0.00                 |         |        |              | <i>10</i>     |               |                  | <i>DAS 39</i><br>DEC 16 2016 |
|                                  | Memo                                                                                                                   | 0.00                 |         |        |              |               |               |                  |                              |
| 180*<br>ckaging<br>kaging        | Identify as per dwg & Stock Location: <i>80 Mezz 2</i>                                                                 | 0.00                 |         |        |              | <i>10x</i>    |               | DEC 19 2016      | <i>DAS 26</i><br>9-89        |
|                                  | Memo                                                                                                                   | 0.00                 |         |        |              |               |               |                  |                              |

**Work Order ID 153577**

Tuesday, November 22, 2016 10:34:54 AM

**\*153577\***

Page 4

Item ID: D3447-5

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Clevis

Stop

**\*NS2\***

Start Date: 11/22/2016 Start Qty: 8.00

**\*8\***

Cust Item ID:

Required Date: 12/2/2016 Req'd Qty: 8.00

**\*8\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

**\*190\***

QC

Memo

0.00

Quality Control

DAS  
21  
9-89

DEC 19 2016



DEC 19 2016

# Picklist Print

Tuesday, November 22, 2016 10:34:54 AM

Work Order ID: 153577

**\*153577\***

Parent Item: D3447-5

**\*D3447-5\***

Parent Item Name: Clevis

Start Date: 11/22/2016

Required Date: 12/2/2016

Start Qty: 8.00

Required Qty: 8.00

Comments: AA05.08.26New issueKJ/JLM  
IPP Rev:B Now on Doosan Lathe 08-06-25 JLM Verified By:EC

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M6061T6R1.000                   |                        | Purchased     |             |                     | No               | 100             | f                  | 32.0000        | 0.3167      | 2.666947     |               |                |        |

**\*M6061T6R1 000\***

**\*\***

ROUND BAR 1.00"

Location

Loc Qty

Loc Code

MAT012

32

m134553

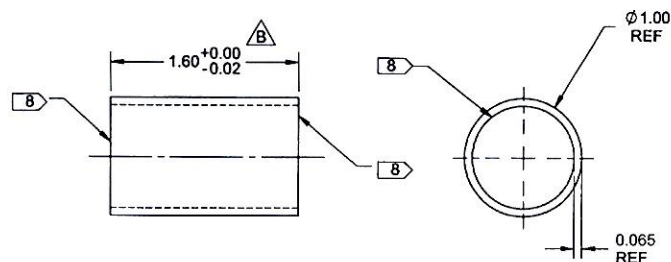
12

m135612 -

20

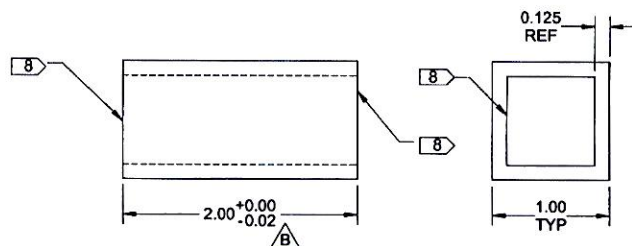
3.292 *P 16-11-27*





#### D3447-1 ROUND SPACER

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) ROUND BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR  
ASTM B221  
REF. DART SPEC. M6061T6T1.000W.065



#### D3447-3 SQUARE SPACER

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) SQUARE TUBING  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
REF. DART SPEC. M6061T6T1.000W.125

#### NOTES:

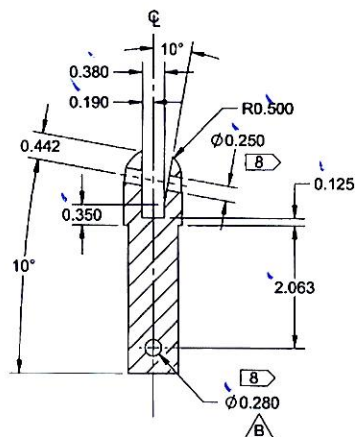
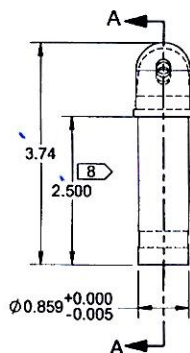
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A OR PER QSI 044 6.1
- 7) WEIGHT: D3447-1 = 0.03 lbs; D3447-3 = 0.09 lbs
- 8) MASKING: INSIDE OF TUBING AND ENDS BEFORE PAINTING.

RELEASED  
2016-11-09

| B          | REDRAW TO CURRENT STD; Ø0.280 WAS Ø0.250 (ZN B3-2) AND (ZN C8-3), ADD TOLERANCE (ZN B5/DS-1), UPDATED MATERIAL SPECIFICATION, REASON PAR15-437 | SAD                                                                                                                                                                                                                                                                                                                                                                                                               | 16.08.26 |
|------------|------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------|
| A          | NEW ISSUE                                                                                                                                      | MB                                                                                                                                                                                                                                                                                                                                                                                                                | 05.07.19 |
| REV.       | DESCRIPTION                                                                                                                                    | BY                                                                                                                                                                                                                                                                                                                                                                                                                | DATE     |
| DESIGN     | MB                                                                                                                                             | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA<br>DRAWING NO. <b>D3447</b><br><b>BLADE FOLD KIT PARTS</b><br><small>COPYRIGHT © 2005 BY DART AEROSPACE LTD<br/>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE FURTHER CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small> |          |
| DRAWN      | SAD                                                                                                                                            |                                                                                                                                                                                                                                                                                                                                                                                                                   |          |
| CHECKED    | MB                                                                                                                                             |                                                                                                                                                                                                                                                                                                                                                                                                                   |          |
| MFG. APPR. | JLM                                                                                                                                            |                                                                                                                                                                                                                                                                                                                                                                                                                   |          |
| APPROVED   | WM                                                                                                                                             |                                                                                                                                                                                                                                                                                                                                                                                                                   |          |
| DE APPR.   | N/A                                                                                                                                            | REV. B                                                                                                                                                                                                                                                                                                                                                                                                            |          |
| DATE       | 16.08.26                                                                                                                                       | SHEET 1 OF 4                                                                                                                                                                                                                                                                                                                                                                                                      |          |
|            |                                                                                                                                                | SCALE                                                                                                                                                                                                                                                                                                                                                                                                             |          |
|            |                                                                                                                                                | NTS                                                                                                                                                                                                                                                                                                                                                                                                               |          |

APPROVED

Ø 1.00  
REF



**SECTION A-A**

**D3447-5 CLEVIS**

**SUPERSEDES PREMIER P/N B67-43001-99**

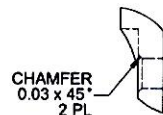
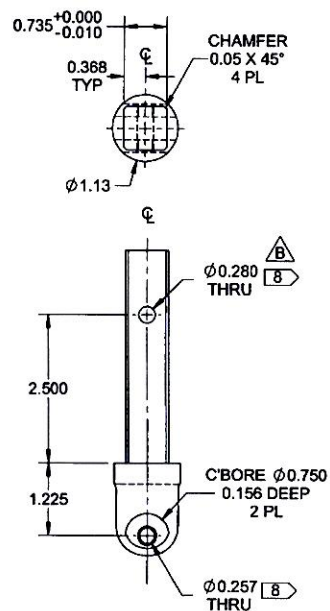
**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) ROUND BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR  
ASTM B221  
REF. DART SPEC. M6061T6R1.000
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3.
- 3) TOLERANCES: ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EAGED 0.005 TO 0.010
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.07 lbs
- 8) MASKING: COVER LOCATION AND INSIDE HOLES AS SHOWN PRIOR TO PAINTING

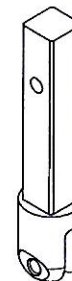
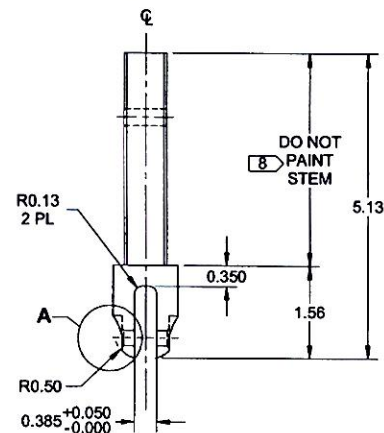
RELEASED  
2016-11-09

APPROVED

|            |          |                                                                                                                                                                                                                                                                                |              |
|------------|----------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN     | MB       | <b>DART AEROSPACE LTD</b>                                                                                                                                                                                                                                                      |              |
| DRAWN      | SAD      | HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                                                    |              |
| CHECKED    | MB       | DRAWING NO.                                                                                                                                                                                                                                                                    | REV. B       |
| MFG. APPR. | JLM      | <b>D3447</b>                                                                                                                                                                                                                                                                   | SHEET 2 OF 4 |
| APPROVED   | WM       | TITLE                                                                                                                                                                                                                                                                          | SCALE        |
| DE APPR.   | N/A      | <b>BLADE FOLD KIT PARTS</b>                                                                                                                                                                                                                                                    | NTS          |
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DETAIL A  
SCALE 1:1



# D3447-7 CLEVIS

SUPERCEDES PREMIER P/N B67-43001-145/-345

## NOTES:

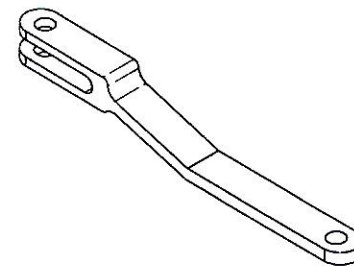
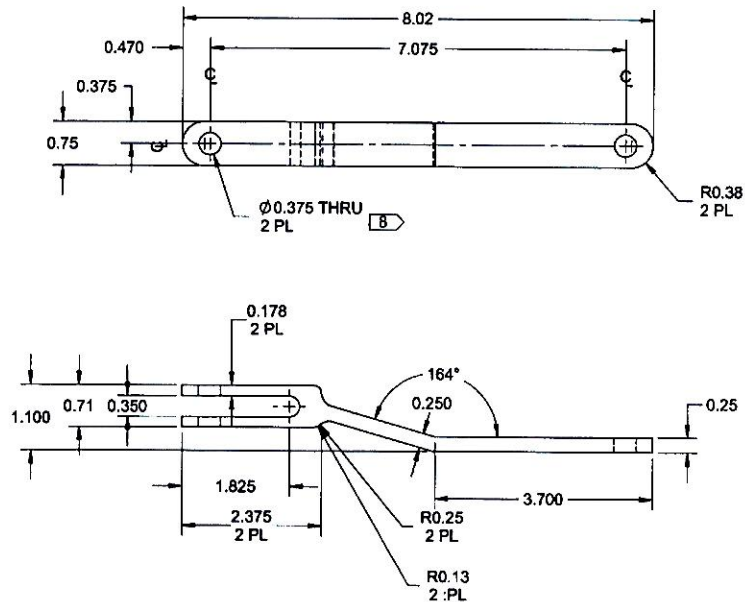
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) ROUND BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR  
ASTM B221  
REF. DART SPEC. M6061T6R1.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EAGED 0.005 TO 0.010
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs
- 8) MASKING: COVER INSIDE HOLES AS SHOWN PRIOR TO PAINTING

RELEASED  
2016-11-09

APPROVED

|            |          |                                                                                                                                                                                                                                                                               |              |
|------------|----------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN     | MB       | <b>DART AEROSPACE LTD</b>                                                                                                                                                                                                                                                     |              |
| DRAWN      | SAD      | HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                                                   |              |
| CHECKED    | MB       | DRAWING NO.                                                                                                                                                                                                                                                                   | REV. B       |
| MFG. APPR. | JLM      | <b>D3447</b>                                                                                                                                                                                                                                                                  | SHEET 3 OF 4 |
| APPROVED   | WM       | TITLE                                                                                                                                                                                                                                                                         | SCALE        |
| DE APPR.   | N/A      | <b>BLADE FOLD KIT PARTS</b>                                                                                                                                                                                                                                                   | NTS          |
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# **D3447-9 SWING ARM**

**SUPERSEDES PREMIER P/N B67-43001-263**

## **NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) ROUND BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR  
ASTM B221  
REF. DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.33
- 3) TOLERANCES: ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EAGED 0.005 TO 0.010
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.06 lbs
- 8) MASKING: COVER INSIDE HOLES AS SHOWN PRIOR TO PAINTING

**RELEASED**  
2016-11-09

APPROVED

|            |          |                                                                                                                                                                                                                                                                                                  |              |
|------------|----------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN     | MB       | <b>DART AEROSPACE LTD</b>                                                                                                                                                                                                                                                                        |              |
| DRAWN      | SAD      | HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                                                                      |              |
| CHECKED    | MB       | DRAWING NO.                                                                                                                                                                                                                                                                                      | REV. B       |
| MFG. APPR. | JLM      | <b>D3447</b>                                                                                                                                                                                                                                                                                     | SHEET 4 OF 4 |
| APPROVED   | WM       | TITLE                                                                                                                                                                                                                                                                                            | SCALE        |
| DE APPR.   | N/A      | <b>BLADE FOLD KIT PARTS</b>                                                                                                                                                                                                                                                                      | NTS          |
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|                              |                               |                             |
|------------------------------|-------------------------------|-----------------------------|
| <b>DART AEROSPACE LTD</b>    |                               | <b>Work Order:</b> 153577   |
| <b>Description:</b> Clevis   |                               | <b>Part Number:</b> D3447-5 |
| <b>Inspection Dwg:</b> D3447 | <b>Rev:</b> A <i>16-11-27</i> | <b>Page 1 of 1</b>          |

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance                | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|--------------------------|------------------|--------|--------|----------------------|----------|
| 3.74              | +/-0.030                 | 3.750            |        |        | Vern LPO9            |          |
| 2.500             | +/-0.010                 | 2.498            |        |        | ↓                    |          |
| Ø0.859            | +0.000/-0.005            | .856             |        |        | Mic LPO1             |          |
| 10°               | +/-0.5°                  | 10°              | ✓      |        | Digital angle gauge  |          |
| 0.380             | +/-0.010                 | .375             |        |        | Vern LPO9            |          |
| 0.190             | +/-0.010                 | .188             |        |        | Height gauge         |          |
| 0.442             | +/-0.010                 | 0.442            | ✓      |        | Caliper              | JCL-08   |
| R0.50             | +/-0.030                 | .500             |        |        | Vern LPO9            |          |
| 0.125             | +/-0.010                 | .122             |        |        | ↓                    |          |
| 0.350             | +/-0.010                 | 0.354            | ✓      |        | Caliper              | JCL-08   |
| <del>Ø0.250</del> | <del>+0.005/-0.001</del> |                  |        |        |                      |          |
| 10°               | +/-0.5°                  | 10°              | ✓      |        | Digital angle Gauge  |          |
| 2.063             | +/-0.010                 | 2.061            |        |        | Height gauge         |          |
| Ø0.250            | +0.005/-0.001            | 0.252            | ✓      |        | Caliper              | JCL-08   |
| 1.00              | +/-0.030                 | 1.000            |        |        | Vern LPO9            |          |
| Ø.280             | +0.006/-0.001            | .283             |        |        | Gage pin             |          |
|                   |                          |                  |        |        |                      |          |
|                   |                          |                  |        |        |                      |          |
|                   |                          |                  |        |        |                      |          |
|                   |                          |                  |        |        |                      |          |
|                   |                          |                  |        |        |                      |          |
|                   |                          |                  |        |        |                      |          |
|                   |                          |                  |        |        |                      |          |
|                   |                          |                  |        |        |                      |          |

|                                     |                                |                            |     |
|-------------------------------------|--------------------------------|----------------------------|-----|
| <b>Measured by:</b> <i>16-11-27</i> | <b>Audited by:</b> DAS 44 9-89 | <b>Prototype Approval:</b> | N/A |
| <b>Date:</b> 16-11-30               | <b>Date:</b> 16-11-30          | <b>Date:</b>               | N/A |

| Rev | Date     | Change    | Revised by            | Approved        |
|-----|----------|-----------|-----------------------|-----------------|
| A   | 08.07.24 | New Issue | KJ/DD <i>16-11-30</i> | <i>16-11-30</i> |